Dart Aerospace Ltd. Monday, 03/11/2008 10:39:03 AM Date: User: Julie Dawson **Process Sheet** Customer : CU-DAR001 Dart Helicopters Services **Drawing Name** : FRAME Job Number : 43139 : 10300 **Estimate Number** : D32241 P.O. Number **Part Number** : 03/11/2008 **Drawing Number** : D3224 REV A This Issue : N/A : NC Prsht Rev. **Project Number** : // : SMALL /MED FAB First Issue **Drawing Revision** Type : 35458A **Previous Run** Material **Due Date** : 07/11/2008 Qty: 8 Um: Written By Checked & Approved By 05-11-06 JLM Comment New Issue : Est Rev:A EC Est: B 06.11.15 waterjet **Additional Product** Job Number: Description: Seq. #: **Machine Or Operation:** M2024T3S063 2024-T3 .063 sheet 1.0 Comment: Qty.: 5.4600 sf(s)/Unit Total: 43.6800 sf(s) 2024-T3 .063 thick aluminum sheet Batch: 109 4 63 WATER JET 2.0, Comment: FLOW WATER JET 1-Cut as per Dwg D3224 Dwg Rev:__ B8-11-4 Prog Rev: 2-Deburr if necessary INSPECT PARTS AS THEY COME OFF MACHINE QC2 3.0 R8-11-4 Comment: INSPECT PARTS AS THEY COME OFF MACHINE SECOND CHECK 4.0 QC8 Comment: SECOND CHECK SMALL FAB SMALL & MEDIUM FAB RESOURCE 1 5.0

Comment: SMALL & MEDIUM-FAB RESOURCE 1 Deburr



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Dart Aerospace Ltd

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W/O:			WORK ORDER	CHANGES					
DATE	STEP	PROCEDURE CHANGE			By D	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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Part No):	PAR #:	Fault Category:	NCR:	Yes N	lo DQ	A:	Date: _	
Resolution:		solution:	Disposition:	QA: N	I/C Clo	sed:		Date: _	
NCR:			WORK ORDER NON-CON	IFORMANCE (NCR)				
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NCR:			WORK ORDE	ER NON-CONFORMANO	CE (NCR)			
		Description of NC	Corrective Action Section B			Verification Ap	Approval	Approval
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

Monday, 03/11/2008 10:39:03 AM Date: User: Julie Dawson **Process Sheet** Drawing Name: FRAME Customer: CU-DAR001 Dart Helicopters Services Part Number: D32241 Job Number: 43139. Job Number: Seq. #: Description: **Machine Or Operation:** NC BRAKE BRAKE NC 6.0 Comment: NC BRAKE Form as per Dwg D3224 7.0 QC5 INSPECT WORK TO CURRENT STEP Comment: INSPECT WORK TO CURRENT STEP 8.0 HAND FINISHING RESOURCE #1 HAND FINISHING1 Comment: HAND FINISHING RESOURCE #1 Chemical Conversion Coat as per QSI 005 4.1 INSPECT POWDER COAT/CHEMICAL CONVERSI 9.0 QC3 Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION PACKAGING RESOURCE #1 10.0 PACKAGING 1 Comment: PACKAGING RESOURCE #1 Identify and Stock Location: FINAL INSPECTION/W/O RELEASE 11.0 QC21 Comment: FINAL IN TION/W/O RELEASE 08-11-18 Job Completion

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W/O:			WC	RK ORDER CHANGE	S	·			
DATE STEP		PROCEDURE CHANGE			Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
Part No: PAR #:		PAR #:	Fault Cate	gory:	NCR: Yes	No DQ	A :	Date: _	
Resolution:			Disposition: Q			QA: N/C Closed: [
NCR:		٠	WORK ORDI	ER NON-CONFORMAN	NCE (NC	R)			
DATE	STEP	Description of NC	Corrective Action				/erification Approv		
57(12	0121	Section A	Initial Chief Eng	Action Description Chief Eng	Date		ion C	Chief Eng	QC Inspector
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NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	43139
Description: Frame	Part Number:	D3224-1
Inspection Dwg: D3224 Rev: A		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X	First Article		Prototype
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Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
	1/0.020		6		<u> </u>	
25.50	+/-0.030	25.50	8			
30.63	+/-0.030		W.			
1.900	+/-0.010	1.906	K			
2.025	+/-0.010	2.078	X			
1.640	+/-0.010	1.647	X7			
1.950	+/-0.010	1.955	D			
2.080	+/-0.010	780.c	×			
0.063	+/-0.010	1065	6			
2.383	+/-0.010	2.389	X			
		-		-		
	-					
					<u></u>	

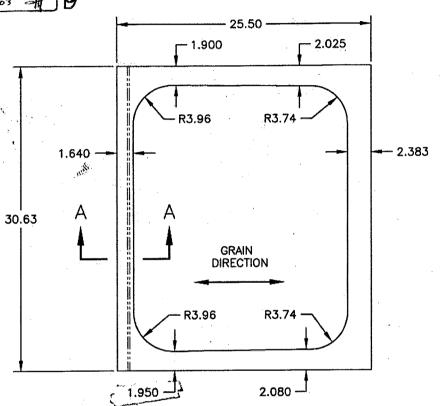
<u> </u>					
Measured by:	HB	Audited by:	\geq_{i}	Prototype Approval:	N/A
Date:	8-10-4	Date:	08/11/64	Date:	N/A

Rev	Date	Change		Revised by	Approv <i>e</i> c	\sqcup
Α	04.10.05	New Issue	P/O D412-709-011	KJ/JLM	<u> </u>	
				- 7	//-/	

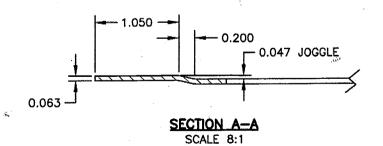


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DESIGN	DRAWN BY	DART AERO HAWKESBURY, C	SPACE LTD NTARIO, CANADA
CHECKED A	APPROVED	DRAWING NO.	REV. A
#	Al-	D3224	SHEET 1 OF 1
DATE		TITLE	SCALE
03.10.21		FRAME	NTS
 Α	03.10.21	NEW ISSUE	





D3224-1



SHOP COPY RETURN TO ENGINEERING UNCONTROLLED COPY SUBJECT TO AMENDMENT WITHOUT NOTICE

1) BREAK ALL UNMARKED SHARP EDGES 0.010 TO 0.020

MATERIAL: 2024-T3 (QQ-A-250/4), 0.063 THICK (REF. M2024T3S.063) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1 ALL DIMENSIONS ARE IN INCHES TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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